

Work Order ID 160315

Tuesday, April 25, 2017 2:16:24 PM

160315

Page 1

Item ID: D4006-041 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Tank Top Support Assembly
Start Date: 5/3/2017 Start Qty: 2.00 ***2*** Cust Item ID:
Required Date: 5/10/2017 Req'd Qty: 2.00 ***2*** Customer:
Reference: (P.A.)SCHEDULED/S

Approvals: Process Plan: **DAS 21 9-89** Date: **APR 26 2017** Tooling: Date: Run Start ***NR1***
QC: Date: SPC (Y/N): Date: Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
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D4006	B 
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100		0.00							
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100

Small Fab

Memo

0.37

Small Fab

Assemble as per dwg D4006

110	QC5- Inspect part completeness to step on W/O	0.00							
-----	---	------	--	--	--	--	--	--	--

110

QC

Memo

0.04

Quality Control

120	Gloss Grey (4.3.5.15) per QSI 005 4.3	0.00							
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120

Powdercoat

Memo

0.44

Powder Coating

Start Time: **11:05**
Oven Temperature: **320°**
Finish Time: **11:35**

DAS 36 9-89**17/05/18****DAS 38 9-89****MAY 19 2017****2 @ 1705:30**

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :				MRB (QSI042) Approval Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval	
Description Work Order Deviation				Disposition					

Root Cause			FAULT CATEGORY					
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐			
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐			
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐			
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐			
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐			
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐			
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐			
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐			
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐			
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐			
Past Expiry Date ☐	Manufacturing Process ☐	OTHER : _____						
Misidentified ☐	Past Due ☐							

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[illegible]

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Reference: (P.A.)SCHEDULED/S

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160	Identify as per dwg & Stock Location: <i>5242</i>	0.00							
160						<i>2</i>	DAS 6 9-89	<i>MAY 31 2017</i>	
Packaging	Memo	0.02							
Packaging									
170	QC21- Final Inspection - Work Order Release	0.00							
170									<i>17/6/17</i>
QC	Memo	0.20							
Quality Control									

DAS
21
9-89

MAY 31 2017

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS <table style="width:100%; border: none;"> <tr> <td style="border: none;">Skid-tube ☐</td> <td style="border: none;">Cross tube ☐</td> <td style="border: none;">Water Jet ☐</td> <td style="border: none;">Engineering ☐</td> </tr> <tr> <td style="border: none;">Machining ☐</td> <td style="border: none;">Small Fab ☐</td> <td style="border: none;">Prod. Eng. Coord. ☐</td> <td style="border: none;">Quality ☐</td> </tr> <tr> <td style="border: none;">Thermoforming ☐</td> <td style="border: none;">Finishing ☐</td> <td style="border: none;">Rec/Store/Packaging ☐</td> <td style="border: none;">Other ☐</td> </tr> <tr> <td style="border: none;">Large Fab ☐</td> <td style="border: none;">Composite ☐</td> <td style="border: none;">Supplier ☐</td> <td></td> </tr> </table>						Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
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OTHER : ☐																									

Picklist Print

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Page 1

Work Order ID: 160315

160315

Parent Item: D4006-041

D4006-041

Parent Item Name: Tank Top Support Assembly

Start Date: 5/3/2017

Required Date: 5/10/2017

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP rev A 09.12.18 new issue Prelim EC verified by:DD IPP Rev:B
10.05.03 as per ECN10-562 DD verified by:EC
IPP Rev:C 10.07.12 added type of glue DD verf:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D4006-1 *D4006-1* Angle		Manufactured	No			100	Each	3.0000	1	2		17/05/18	DAS 36 9-89
				<u>Location</u>				<u>Loc Qty</u>					
				GA				3					
					144475			3					
D4006-3 *D4006-3* Channel		Manufactured	No			100	Each	2.0000	2	4		17/05/18	DAS 36 9-89
				<u>Location</u>				<u>Loc Qty</u>					
				GA				2					
					141570			2					
D4006-5 *D4006-5* Foam		Manufactured	No			140	Each	4.0000	1	2		17/05/31	DAS 36 9-89
				<u>Location</u>				<u>Loc Qty</u>					
				ST070				4					
					144477			4					

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Page 2

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Parent Item: D4006-041

D4006-041

Parent Item Name: Tank Top Support Assembly

Start Date: 5/3/2017

Required Date: 5/10/2017

Start Qty: 2.00

Required Qty: 2.00

MS20426AD3-4

Purchased

No

140

Each

8,212.000

4

8

MS20426AD3-4

RIVET

**

17/05/31
DAS
36
9-89

Location

Loc Qty

Loc Code

GA

6474

m134294

1921

m136444

4553

ST312

1738

m134294

1738

8

MS20470AD4-5

Purchased

No

100

Each

1,988.000

8

16

MS20470AD4-5

RIVET, UNIVERSAL HEAD

**

17/05/18
DAS
36
9-89

Location

Loc Qty

Loc Code

GA

1664

m136851

1664

ST310

324

m134654

324

16

MS21059L4

Purchased

No

140

Each

33.0000

2

4

MS21059L4

Nutplate

**

17/05/31
DAS
36
9-89

Location

Loc Qty

Loc Code

ST301

33

m137178

8

m137320

25

4

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Shop Packet Print

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